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D3296-1

Job Sheet 204648



Part No: D3296-1

Job Qty: 12 pcs

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/16/19

Job Tracking No:

Due Date: 1/17/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		1/17/20	0.03	1.24	Waterjet - Flow		
120	QC 8	12 pcs		1/17/20	0.00	0.00	QC 8 - 12		TF March 13, 2020
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
140	Handfinish - 1-1 Chemical-B4B	12 pcs		1/17/20	0.00	0.64	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		

DAS 40 9-89

DAS 82 9-89

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				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 7	12 pcs	1/17/20	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43

DAS
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9-B9

160 Packaging 3-1 - Stock - B4B	12 pcs	1/17/20	0.00 0.00	QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	DAS
				Packaging 3 - 31 - B4B	21
				Packaging 3 - 32 - B4B	9-30
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	12 pcs	1/17/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-30

Part Op 120 - QC8- Inspect parts - second check
 Descriptions: 140 - Chemical Conversion Coat per QSI005 4.1
 150 - QC7-Inspect Chemical Conversion Coat
 160 - Identify as per dwg & Stock Location: _____
 170 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	7.9152 sf (.6596 ea)	100-Waterjet - Flow - 1	522838 5216341

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	8	92	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches $\pm$ 0.030	5.110 5.050	5.089	
2	Door Panel	0.060inches $\pm$ 0.030	0.090 0.030	0.060	
3	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0.297	
4	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128	0.129	
5	Door Panel	16.400inches $\pm$ 0.005	16.405 16.395	16.400	
6	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0.298	
7	Door Panel	13.400inches + 0.005 - 0.030	13.405 13.370	13.400	
8	Door Panel	17.000inches $\pm$ 0.030	17.030 16.970	17.000	
9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150	14.180	
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0.300	
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053	0.065	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S263467



Part: D3296-1

Job No: 204648

Serial No/Batch: S263467

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/13/20